

This Page Is Inserted by IFW Operations
and is not a part of the Official Record

BEST AVAILABLE IMAGES

Defective images within this document are accurate representations of the original documents submitted by the applicant.

Defects in the images may include (but are not limited to):

- BLACK BORDERS
- TEXT CUT OFF AT TOP, BOTTOM OR SIDES
- FADED TEXT
- ILLEGIBLE TEXT
- SKEWED/SLANTED IMAGES
- COLORED PHOTOS
- BLACK OR VERY BLACK AND WHITE DARK PHOTOS
- GRAY SCALE DOCUMENTS

IMAGES ARE BEST AVAILABLE COPY.

**As rescanning documents *will not* correct images,
please do not report the images to the
Image Problem Mailbox.**

PCTWORLD INTELLECTUAL PROPERTY ORGANIZATION
International Bureau

INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(51) International Patent Classification ⁶: C07C 5/333	A1	(11) International Publication Number: WO 96/13475 (43) International Publication Date: 9 May 1996 (09.05.96)
(21) International Application Number: PCT/US95/12605 (22) International Filing Date: 29 September 1995 (29.09.95) (30) Priority Data: 08/330,201 27 October 1994 (27.10.94) US (71) Applicant: REGENTS OF THE UNIVERSITY OF MINNESOTA [US/US]; 1100 Washington Avenue, Minneapolis, MN 55415 (US). (72) Inventors: SCHMIDT, Lanny, D.; 1100 Washington Avenue, Minneapolis, MN 55415 (US). HUFF, Marilyn; 1100 Washington Avenue, Minneapolis, MN 55414 (US). (74) Agent: JOHNSON, Kenneth, H.; P.O. Box 630708, Houston, TX 77507 (US).		(81) Designated States: AM, AT, AU, BB, BG, BR, BY, CA, CH, CN, CZ, DE, DK, EE, ES, FI, GB, GE, HU, IS, JP, KE, KG, KP, KR, KZ, LK, LR, LT, LU, LV, MD, MG, MN, MW, MX, NO, NZ, PL, PT, RO, RU, SD, SE, SG, SI, SK, TJ, TM, TT, UA, UG, UZ, VN, European patent (AT, BE, CH, DE, DK, ES, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, ML, MR, NE, SN, TD, TG), ARIPO patent (KE, MW, SD, SZ, UG). Published <i>With international search report.</i>
(54) Title: CATALYTIC OXIDATIVE DEHYDROGENATION PROCESS (57) Abstract A process for the production of a mono-olefin from a gaseous paraffinic hydrocarbon having at least two carbon atoms or mixtures thereof comprising reacting said hydrocarbons and molecular oxygen in the presence of a platinum catalyst. The catalyst consists essentially of platinum supported on alumina or zirconia monolith, preferably zirconia and more preferably in the absence of palladium, rhodium and gold.		

FOR THE PURPOSES OF INFORMATION ONLY

Codes used to identify States party to the PCT on the front pages of pamphlets publishing international applications under the PCT.

AT	Austria	GB	United Kingdom	MR	Mauritania
AU	Australia	GE	Georgia	MW	Malawi
BB	Barbados	GN	Guinea	NE	Niger
BE	Belgium	GR	Greece	NL	Netherlands
BF	Burkina Faso	HU	Hungary	NO	Norway
BG	Bulgaria	IE	Ireland	NZ	New Zealand
BJ	Benin	IT	Italy	PL	Poland
BR	Brazil	JP	Japan	PT	Portugal
BY	Belarus	KE	Kenya	RO	Romania
CA	Canada	KG	Kyrgyzstan	RU	Russian Federation
CF	Central African Republic	KP	Democratic People's Republic of Korea	SD	Sudan
CG	Congo	KR	Republic of Korea	SE	Sweden
CH	Switzerland	KZ	Kazakhstan	SI	Slovenia
CI	Côte d'Ivoire	LI	Liechtenstein	SK	Slovakia
CM	Cameroon	LK	Sri Lanka	SN	Senegal
CN	China	LU	Luxembourg	TD	Chad
CS	Czechoslovakia	LV	Latvia	TG	Togo
CZ	Czech Republic	MC	Monaco	TJ	Tajikistan
DE	Germany	MD	Republic of Moldova	TT	Trinidad and Tobago
DK	Denmark	MG	Madagascar	UA	Ukraine
ES	Spain	ML	Mali	US	United States of America
FI	Finland	MN	Mongolia	UZ	Uzbekistan
FR	France			VN	Viet Nam
GA	Gabon				

CATALYTIC OXIDATIVE DEHYDROGENATION PROCESS

BACKGROUND OF THE INVENTION

Field of the Invention

5 This invention relates to a process for the dehydrogenation of dehydrogenatable hydrocarbons in the presence of a selective oxidation/dehydrogenation catalyst and an oxygen-containing gas. This invention was made with government support under grant number DE-FG02-88ER13878-A02 awarded by the Department of Energy. The government has
10 certain rights in the invention.

The dehydrogenation of hydrocarbons is an important commercial process. This is because of the great demand for dehydrogenated hydrocarbons as feedstocks for industrial processes. For example, dehydrogenated
15 hydrocarbons are utilized in the manufacture of various products such as detergents, high octane gasolines, and pharmaceutical products among others. Plastics and synthetic rubbers are other products which may be produced through use of dehydrogenated hydrocarbons. One example of
20 a specific dehydrogenation process is dehydrogenating isobutane to produce isobutene which may be etherified to produce gasoline octane improvers, polymerized to provide adhesive tackifying agents, viscosity-index additives and plastic anti-oxidants.

25 Related Art

Various reticulated ceramic structures are described in the art: U.S. Pat. No. 4,251,239 discloses fluted filter of porous ceramic having increased surface area; U.S. Pat. No. 4,568,595 discloses reticulated ceramic foams with a
30 surface having a ceramic sintered coating closing off the cells; U.S. Pat. No. 3,900,646 discloses ceramic foam with a nickel coating followed by platinum deposited in a vapor process; U.S. Pat. No. 3,957,685 discloses nickel or palladium coated on a negative image ceramic metal/ceramic
35 or metal foam; U.S. Pat. No. 3,998,758 discloses ceramic foam with nickel, cobalt or copper deposited in two layers with the second layer reinforced with aluminum, magnesium or zinc; U.S. Pat. Nos. 4,810,685 and 4,863,712 disclose

negative image reticulated foam coated with active material, such as, cobalt, nickel or molybdenum coating; U.S. Pat. No. 4,308,233 discloses a reticulated ceramic foam having an activated alumina coating and a noble metal coating useful as an exhaust gas catalyst; U.S. Pat. No. 4,253,302 discloses a foamed ceramic containing platinum/rhodium catalyst for exhaust gas catalyst; and U.S. Pat. No. 4,088,607 discloses a ceramic foam having an active aluminum oxide layer coated by a noble metal containing composition such as zinc oxide, platinum and palladium.

The supports employed in the present invention are generally of the type disclosed in U.S. Pat. No. 4,810,685 using the appropriate material for the matrix and are generally referred to in the art and herein as "monoliths".

The monoliths with various catalytic materials deposited thereon have also been employed for the production of synthesis gas (PCT WO 90/06279) and nitric acid (U.S. Pat. No. 5,217,939)

U.S. Pat. No. 4,940,826 (Freide, et al) discloses the oxidative dehydrogenation of gaseous paraffinic hydrocarbons having at least 2 carbon atoms or a mixture thereof by contacting the hydrocarbon with molecular oxygen containing gas over a supported platinum catalyst where the support is alumina such as gamma alumina spheres and monoliths such as cordierite or mullite. The desired products are the corresponding olefins.

SUMMARY OF THE INVENTION

Briefly the present invention is a process for the production of a mono-olefin from a gaseous paraffinic hydrocarbon having at least two carbon atoms or mixtures thereof comprising reacting said hydrocarbons and molecular oxygen in the presence of a platinum catalyst, preferably in the substantial absence of Pd, Rh and Au on a monolith support.

The composition of the ceramic support can be any oxide or combination of oxides that is stable at the high temperatures of operation, near 1000°C. The support

material should have a low thermal expansion coefficient. The components of the oxide support should not phase separate at high temperatures since this may lead to loss of integrity. Components of the oxide support should not
5 become volatile at the high reaction temperatures. Suitable oxide supports include the oxides of Al (α -Al₂O₃), Zr, Ca, Mg, Hf, and Ti. Combinations of these can be produced to tailor the heat expansion coefficient to match the expansion coefficient of the reactor housing.

10 The structure and composition of the support material is of great importance. The support structure affects the flow patterns through the catalyst which in turn affects the transport to and from the catalyst surface and thus the effectiveness of the catalyst. The support structure
15 should be macroporous with 30 to 80 pores per linear inch. The pores should yield a tortuous path for the reactants and products such as is found in foam ceramics. Straight channel extruded ceramic or metal monoliths yield suitable flow dynamics only if the pore size is very small with >80
20 pores per linear inch.

The preferred catalyst of the present invention consists essentially of platinum supported on a ceramic foam monolith, preferably on zirconia or α -alumina, and more preferably on zirconia. The platinum should be deposited
25 on the surface of the ceramic to a loading of 0.2 to 90 wt. %, preferably 2 to 10 wt. %, and more preferably in the absence of palladium, rhodium, and gold. It has been found that palladium causes the catalyst to coke up and deactivate very quickly and thus should be excluded in any
30 amount that is detrimental to the effectiveness of the catalyst. Though rhodium does not lead to catalyst deactivation the product distribution is less favorable. The presence of gold leads to a less active catalyst.

Preferably the Pt is supported on an alpha-alumina or
35 zirconia ceramic foam monolith with 30 to 80 pores per linear inch, 30 to 70% void fraction, created in such a way to yield a tortuous path for reactants. The Pt may be supported on a ceramic foam monolith comprised of any

combination of alpha-alumina, zirconia, titania, magnesia, calcium oxide, or hafnium oxide such that the support is stable up to 1100°C and does not undergo detrimental phase separation that leads to loss in catalyst integrity.

- 5 The catalyst may comprise platinum on the alumina or zirconia monolith support.

BRIEF DESCRIPTION OF THE DRAWINGS

10 Figure 1 shows the carbon atom and hydrogen atom selectivities, the ethane conversion, and the reaction temperature for feed mixtures of ethane and air as a function of feed composition.

Figure 2 shows the selectivities, conversion, and reaction temperature for ethane oxidation in O₂ as a function of feed composition.

15 Figure 3 illustrates the effect of preheat on the selectivities, conversion, and reaction temperature in ethane oxidation.

20 Figure 4 illustrates the effect of flow rate on the selectivities, conversion, and reaction temperature for the same catalyst sample at a feed composition of 25% ethane in air.

Figure 5 shows the selectivities, conversion, and reaction temperature for ethane oxidation in O₂ over a Rh catalyst.

25 Figure 6 shows the carbon atom and hydrogen atom selectivities and the propane conversion for the oxidation of propane in air over the 5.1 wt % Pt catalyst as a function of the C₃H₈/O₂ ratio in the feed.

30 Figure 7 shows the carbon atom and hydrogen atom selectivities, the propane conversion, and the reaction temperature as the level of dilution decreases.

Figure 8 shows the variation in selectivities and conversion with the n-C₄H₁₀/O₂ ratio at a fixed level of 50% N₂ dilution.

35 Figure 9 shows the carbon atom and hydrogen atom selectivities, conversion, and the reaction temperature for the oxidation of isobutane in air over a 5.1 wt. % Pt/ α -AlO₃ catalysts as a function of the fuel/O₂ ratio in the

feed.

Figure 10 shows the effect of a reduction in the amount of N₂ diluent present in the reactant stream.

Figure 11 shows isobutane oxidation in O₂ (20% N₂) over a 1.8 wt. % Pt/ZrO₂ catalysts.

DETAILED DESCRIPTION OF PREFERRED EMBODIMENTS

The paraffins which are suitable for the present process are generally those that can be vaporized at temperatures in the range of 25 to 400°C at pressures of 0.1 to 5 atm. These are generally C₂ to C₂₀ carbon atom alkanes either alone or in mixtures, preferably having two to eight carbon atoms. Suitable alkanes include ethane, propane, n-butane isobutane, n-pentane, isoamylenes, n-hexane, isohexanes, n-heptane, isoheptane, octane and isooctanes. Since a preferred embodiment includes a preheating of the feed to the reaction zone, the necessity to heat an alkane feed above ambient temperature to obtain a vaporous feed is not a negative consideration.

The feed may include both linear and branched alkanes. It has been observed in a fuel rich regime for the oxidative dehydrogenation of n-butane that the oxygen is completely consumed, whereas for the isobutane oxidations it is not. This oxygen breakthrough suggests a rate limiting step for isobutane. It is a proposed theory that the rates of these reactions should be related to the strengths of C-H bonds that must be broken. Thus, it may be desirable to preheat those feeds which are determined to have relatively strong C-H bonds to increase the rate of the initiation step. The feeds may be preheated to temperatures in the range of 0 to 500°C., preferably 25 to 400°C.

The present invention discloses the catalytic oxidative dehydrogenation of hydrocarbons. Mixtures of hydrocarbons and oxygen are flammable between given compositions. the feed compositions cited in this invention are outside the flammability limits for the cited hydrocarbons. In all cases, the feed compositions are on the fuel-rich side of the upper flammability limit. The compositions range from

2 to 16 times the stoichiometric fuel to oxygen ratios for combustion to CO_2 and H_2O . Some molar ratios are set out below in Table I.

TABLE I

5	Fuel	Operable Fuel/ oxygen molar ratio	Preferred Fuel/ oxygen molar ratio
	Ethane	0.8-2.5	1.5-2.0
10	Propane	0.5-1.5	0.8-1.3
	n-Butane	0.45-1.0	0.6-0.8
	i-Butane	0.45-2.25	1.4-2.1

As the diluent is reduced and as the reactants are preheated, the flammability limits widen, but it is under these conditions that higher fuel to oxygen ratios (farther from the flammable range) are preferred. This preference is based on catalyst performance with the extra measure of safety an added benefit.

Palladium cokes up rapidly when used alone in the present process. Thus palladium should be excluded in any amount that is detrimental to the effectiveness of the platinum in the dehydrogenation.

Rhodium is not a desirable catalyst component under the conditions of the present reaction since it tends to produce synthesis gas and not olefins. The term "synthesis gas" is understood to mean to a partial oxidation product comprising principally, in varying proportions of hydrogen, carbon monoxide and carbon dioxide. Thus rhodium should be excluded in any amount that is detrimental to the effectiveness of the platinum in the dehydrogenation.

Gold is less active than platinum. It has been found that catalysts prepared according to the present descriptions with gold alone or in combinations with platinum lack sufficient activity in the present process. Thus gold should not be present in the present catalyst in any amount which is detrimental to the activity of the platinum.

Under the conditions of the present process, olefin cracking, CO disproportionation and reverse steam reforming of carbon can occur, and may lead to coke

formation. It has been found by varying the catalyst contact time, the amount of time allowed for these secondary reactions can be controlled. At higher flow rates the olefin products spend less time in contact with the catalyst and higher olefin selectivities and less coking are observed.

The present invention discloses the catalytic oxidative dehydrogenation of hydrocarbons in an autothermal reactor at millisecond contact time. High yields of mono-olefins are obtained with a catalyst contact time ranging from 0.1 to 20 milliseconds when using a ceramic foam monolith of 50% porosity and 0.2 to 1 cm in depth. Under operating conditions, this corresponds to GHSV of 60,000 to 3,000,000 hr^{-1} .

The flow rates are in the range of 60,000-10,000,000 hr^{-1} GHSV, preferably in the range of 300,000 up to 3,000,000 hr^{-1} GHSV may be used.

Under the conditions of the present process it can be determined that several reactions may occur namely (1) complete combustion (strongly exothermic); (2) partial oxidation to syngas (exothermic); (3) oxidative dehydrogenation (exothermic); (4) dehydrogenation (endothermic) and cracking (endothermic).

The overall process can be carried out autothermally. The heat produced by exothermic reactions provides the heat for endothermic reactions. The process does not require the addition of heat.

However, improved results are obtained when moderate amounts of heat are supplied to the system. Preheating the feed shifts the product distribution from the more exothermic reactions (combustion and partial oxidation) to the less exothermic (oxidative dehydrogenation) and endothermic (dehydrogenation and cracking) reactions. Since oxygen is the limiting reactant, this shift improves the process conversion. The selectivity is improved since the less exothermic and endothermic reactions are the desired reactions.

EXAMPLES

The reactor used in the following examples consisted of a quartz tube with an inside diameter of 18 mm containing the catalytic monolith which was sealed into the tube with high temperature alumina-silica cloth that prevented bypass of the reactant gases around the edges of the catalyst. To reduce radiation heat loss and better approximate adiabatic operation, the catalyst was immediately preceded and followed by inert alumina extruded monolith heat shields. The outside of the tube near the reaction zone was insulated.

The catalyst samples were prepared by impregnation of an α -Al₂O₃ or ZrO₂ foam monolith disks 10 to 17 mm in diameter x 0.2 to 1 cm long with saturated solution of metal salts. For the Pt catalysts, a saturated solution of H₂PtCl₆ in water was dripped onto a clean and dry Al₂O₃ foam monolith with 45 or 80 pores per inch (ppi) until the monolith was saturated with liquid. After the catalysts had been dried in N₂, they were calcined in air at 600°C and then reduced in H₂. The Rh, Au and Pd catalysts were prepared similarly using saturated solutions of Rh acetylacetonate, gold chloride in water and Pd acetate in acetone. This process leads to 3-6 wt.% Pt loading for α -Al₂O₃ and 1-2 wt.% Pt loading for ZrO₂ per impregnation step. Higher loadings were achieved by repeating this process.

The catalysts are prepared by depositing Pt or a mixture of Pt and Pd Rh or Au on commercially available ceramic foam monoliths. The foam monoliths, available from Hi-Tech Ceramics, Inc., are composed of either α -Al₂O₃ or ZrO₂ with 30, 45 or 80 pores per linear inch (ppi). It is important to note that these catalysts are not microporous structures. The monoliths are not wash-coated and are estimated to have a surface area of less than 70 cm²/g. Suitable catalysts contain 0.2 to 20 wt% Pt.

Gas flow into the reactor was controlled by mass flow controllers which had an accuracy of \pm 0.1 slpm for all gases. The feed flow rates ranged from 2 to 12 slpm total flow, corresponding to 13 to 79 cm/s superficial velocity

(i.e. the velocity of the feed gases upstream from the catalyst) at room temperature and atmospheric pressure. In all runs, the reactor pressure was maintained at 1.4 atm. The reaction temperature was $\approx 1000^\circ\text{C}$ and contact times were
5 from 0.2 to 40 msec. Product gases were fed through heated stainless steel lines to an automated gas chromatograph.

For quantitative determination of concentrations, standards were used for all species except H_2O , which was obtained most reliably from an oxygen atom balance. To
10 convert the product gas concentrations to molar quantities for a given feed basis, the mole number change due to the chemical reactions was calculated using the measured N_2 concentration. Since N_2 is an inert in this system, the ratio of product gas to feed gas moles was inversely
15 proportional to the ratio of product gas N_2 concentration to feed gas N_2 concentration. Individual species concentrations were measured with a reproducibility estimated to be $\pm 2\%$.

Temperatures were monitored using thermocouples inserted
20 from the front and the rear of the quartz tube in one of the center channels of the inert monolith immediately before or after the catalytic monolith. The reactor was operated at a steady state temperature which is a function of the heat generated by the exothermic and endothermic
25 reactions and the heat losses from the reactor.

The runs were carried out with either air or O_2 as the oxidant. In the runs using O_2 , N_2 was typically added at 20% of the feed as an internal GC calibration standard.

Although the process in steady state is autothermal with
30 feed gases at room temperature, heat was supplied initially to ignite the reaction. A mixture of hydrocarbon and air near the stoichiometric composition for production of synthesis gas was fed to the reactor, and the reactants were heated to the heterogeneous ignition temperature
35 ($\approx 230^\circ\text{C}$ for C_2 to C_4 hydrocarbons). After light-off, the external heat source was removed (unless feed preheating is indicated), the reaction parameters were adjusted to the desired conditions, and steady state was established (≈ 10

min) before analysis. Except where carbon deposition is noted, data shown were reproducible for time periods of at least several hours and on several catalyst samples.

EXAMPLE 1

5 Ethane in Air

Figure 1 shows the carbon atom and hydrogen atom selectivities, the ethane conversion, and the reaction temperature for feed mixtures of ethane and air as a function of feed composition. The feed composition was varied while maintaining a fixed total flow of 5 slpm with room temperature feed. Thermodynamics predicts that between 6 and 17%, selectivities should switch from CO₂ to CO and from H₂O to H₂ and the temperature should be much lower, near 800°C. As seen in figure 1, at 17.4% C₂H₆ in air, 40% selectivity to ethylene at 950°C is observed. This is extraordinary since thermodynamics predicts 100% conversion of ethane to CO and H₂ with no significant by-products.

In Figure 1, C₂H₄ selectivity is seen to peak near a composition of 25% C₂H₆ in air (C₂H₆/O₂ = 1.7) with an optimal selectivity of 52% at 65% conversion of ethane. As the percentage of ethane in the feed increases beyond 25%, ethylene production remains high, but butene is also formed by dimerization of C₂H₄ thus decreasing the apparent C₂H₄ selectivity.

EXAMPLE 2

Ethane in O₂

Figure 2 shows the selectivities, conversion, and reaction temperature for ethane oxidation in O₂ as a function of feed composition. The feed composition was varied while maintaining 20% N₂ in the stream and a fixed total flow of 4.5 slpm with room temperature feed.

The observed trends in the O₂ runs are similar to the trends observed in the air runs (Figure 1). However, the selectivity to C₂H₄ and the C₂H₆ conversion are both significantly higher with 70% and 82%, respectively, at a C₂H₆/O₂ ratio of 1.7. The reaction temperature is also higher, illustrating the effect of reduced N₂ diluent.

EXAMPLE 3

Preheat

Figure 3 illustrates the effect of preheat on the selectivities, conversion, and reaction temperature. The C_2H_6/O_2 ratio was 1.62. The total flow rate was 5 and 4 slpm for the air and O_2 runs, respectively. The ethylene selectivities presented here without preheat differ from the optimum shown in Figures 1 and 2 because the C_2H_6/O_2 ratio and flow rates were sub-optimum in this case.

For the air runs, preheat greatly influenced both the selectivities and the conversion. At $400^\circ C$ preheat C_2H_4 selectivity increased by 40% while the ethane conversion increased to over 80%. The addition of preheat raises the autothermal reaction temperature and provides heat for some endothermic reactions including thermal dehydrogenation of C_2H_6 which would otherwise require heat from the exothermic oxidation of ethane to CO and H_2 . Figure 3 shows that as preheat is increased, less CO and more C_2H_4 are formed. Hydrogen production remains virtually the same since H_2 is also a dehydrogenation product.

In the O_2 runs, increased ethane conversion was observed, but the selectivities remained nearly constant over the range of preheat used. It is important to note that the autothermal temperature is significantly higher in O_2 than in air.

EXAMPLE 4

Flow Rate

Figure 4 illustrates the effect of flow rate on the selectivities, conversion, and reaction temperature for the same catalyst sample at a feed composition of 25% C_2H_6 in air. It is seen that higher flow rates produce both greater C_2H_4 selectivities and greater ethane conversion. At low flows, significantly more H_2O and CO_2 , complete oxidation products are formed which consume the O_2 and thus decrease the conversion of ethane. The H_2O production only drops slightly at the higher flows. No decrease in ethane conversion at flow rates up to 8 slpm corresponding to a contact time of ≈ 10 msec was observed.

EXAMPLE 5

Rh

Figure 5 shows the selectivities, conversion, and reaction temperature for ethane oxidation in O_2 over a 4 wt. % Rh catalyst as a function of feed composition at a fixed total flow of 5 slpm with room temperature feed. In contrast to the results shown in Figure 2 for Pt, syngas production dominates on Rh. At a $C_2H_6:O_2$ ratio of 1.62 C_2H_4 selectivity is only 40% instead of nearly 70% for Pt. Also, significantly less CO_2 is formed as required by the oxygen balance.

EXAMPLE 6

Pd

A run under the standard conditions was conducted using a 1.9 wt % Pd catalyst. Even at the ratio ($C_2H_6/O_2 = 1.0$), coke was forming rapidly. Within 20 minutes, the catalyst was completely deactivated and would not sustain reaction. The initial gas phase products, however, had 16% selectivity to C_2H_4 and 55% selectivity to CO at this feed composition. These are close to the values seen on the Pt catalyst at the syngas ratio, except carbon deposition does not occur on the Pt catalyst.

EXAMPLE 7

In these runs for dehydrogenation of isobutane, comparisons of the monolith and platinum loading were made at two concentrations of isobutane. The conditions and results are set out in TABLE II.

Figure 10 shows isobutane oxidation in O_2 (20% N_2) over a 5.1 wt. % Pt/ Al_2O_3 catalyst. Figure 11 shows isobutane oxidation in O_2 (20% N_2) over a 1.8 wt. % Pt/ ZrO_2 catalyst. The reactants were preheated $360^\circ C$ above ambient before reaching the reaction zone. The reaction temperature over the Pt/ ZrO_2 catalysts is higher than the reaction temperature over the Pt/ Al_2O_3 catalyst by about $50-80^\circ C$. The conversions in Figure 11 are slightly higher than those shown in Figure 10. Less CH_4 is produced over the ZrO_2 support.

13

TABLE II¹

Run	Mole Ratio Isobutene Oxygen	Catalyst ²	Conversion Mole %	Selectivity Mole%			Yield Mole%		
				Olefins	Isobutene	Propene	Olefins	Isobutene	Propene
1	2.00	A	52	83	45	36	43	23	19
2	2.00	B	62	80	41	36	50	52	22
3	2.00	C	55	81	42	36	45	23	20
4	1.43	A	75	75	33	36	56	25	27
5	1.43	B	87	72	25	38	63	22	33
6	1.43	C	85	76	30	38	65	26	33

¹ Conditions: oxidation in O₂ (20% N₂ diluent), total flow rate 5 slpm, 360°C reactant preheat

² A=5.1 wt % Pt on Al₂O₃ monolith; B=1.8 wt % Pt on ZrO₂ monolith; C=2.6 wt % Pt on ZrO₂ monolith.

EXAMPLE 8

Propane + Air

Figure 6 shows the carbon atom and hydrogen atom selectivities and the propane conversion for the oxidation of propane in air over the 5.1 wt % Pt catalyst as a function of the C_3H_8/O_2 ratio in the feed. In these runs, the relative amounts of propane and air were varied while maintaining a fixed total flow of 5 SLPM with room temperature feed.

At the stoichiometric composition for the production of synthesis gas ($C_3H_8/O_2=0.67$) the observed selectivity to ethylene was 30%. In fact, at C_3H_8/O_2 ratios ≥ 0.67 , ethylene and propylene are the dominant products. Ethylene selectivity peaks at about 30% at the synthesis gas stoichiometry with a propane conversion $>95\%$ and propylene selectivity peaks at about 30% near a C_3H_8/O_2 ratio of 1.2 with a propane conversion of about 65%. At C_3H_8/O_2 ratios >0.8 , the total olefin production (C_2H_4 , C_3H_6 , and C_4H_8) remains fairly constant with a selectivity of 55-60%. This selectivity peaks near a C_3H_8/O_2 ratio of 1.0. This is surprising since thermodynamics predicts the production of only CO, H_2 , and graphite in this composition and temperature region. Figure A also shows that the ratio of the ethylene selectivity to the methane selectivity is nearly 2:1 on a carbon atom basis. This corresponds to one mole of ethylene formed for every mole of methane and supports the unimolecular cracking reaction.

EXAMPLE 9

Oxygen enrichment

The optimum olefin yield in air is obtained near a C_3H_8/O_2 ratio of 1.0. Runs were conducted at this C_3H_8/O_2 ratio to examine the effect of N_2 dilution. As shown in Figure 7, the N_2 diluent was decreased from the air composition (62% N_2 at a C_3H_8/O_2 ratio of 1.0) to 36% N_2 diluent (a 1:1 N_2/O_2 ratio). The level of N_2 dilution was not reduced beyond this point because the reaction temperature increased rapidly with decrease in dilution. Throughout this process, the total flow rate was maintained

at 5 SLPM. Figure 7 shows the carbon atom and hydrogen atom selectivities, the propane conversion, and the reaction temperature as the level of dilution decreases.

There is a large effect due to the diluent. This is primarily because the reaction is autothermal, and reduction in N_2 increases the reaction temperature from 940°C in air to 1010°C in the most O_2 enriched case. At the higher temperature, the propane conversion increases very quickly to 100%. Also, the selectivity to ethylene increases to >40% at complete propane conversion and the selectivity to propylene falls. Although ethylene selectivity improves at the higher temperature associated with the oxygen enriched case, total olefin production is slightly higher at the lower temperatures.

EXAMPLE 10

n-Butane + O_2

Figure 8 illustrates the variation in selectivities and conversion with the $n-C_4H_{10}/O_2$ ratio at a fixed level of 50% N_2 dilution. The reactants, n-butane and O_2 (50% N_2) pass over a 5.1 wt. % Pt/ $\alpha-Al_2O_3$ catalyst. Ethylene selectivity peaks near a C_4H_{10}/O_2 ratio of 0.7 and reaches >40% at >95% conversion of n-butane. The propylene selectivity increases as the C_4H_{10}/O_2 ratio increases.

EXAMPLE 11

i-Butane + Air

Figure 9 shows the carbon atom and hydrogen atom selectivities, conversion, and the reaction temperature for the oxidation of isobutane in air over a 5.1 wt. % Pt/ $\alpha-AlO_3$ catalysts as a function of the fuel/ O_2 ratio in the feed. The relative amounts of isobutane and air were adjusted while maintaining a constant total feed flow rate of 5 SLPM with room temperature feed.

Runs were conducted between the stoichiometric fuel/ O_2 ratios for the production of syngas and for oxidative dehydrogenation. Runs were not conducted at fuel/ O_2 ratios less than 0.5 due to the flammability of these mixtures. If only oxidation reactions were occurring, it would be expected that production would shift from CO and H_2 at the

leaner compositions to isobutylene and H_2O at the richer compositions. Figure 9 indeed exhibits this trend. The reaction temperature is also near the adiabatic reaction temperatures for these reactions.

5 Several other reactions, including thermal dehydrogenation and cracking are also taking place. This masks the trend described in the previous paragraph. Syngas production is suppressed in favor of thermal cracking to form C_3H_6 and CH_4 . The production of CO_2 also
10 increases at richer compositions. The oxygen is not completely consumed (85-90% O_2 conversion), but is present in only small quantities. This remaining O_2 may be leading to the higher CO_2 selectivities achieved in $i-C_4H_{10}$ oxidation compared to $n-C_4H_{10}$ oxidation.

15 For isobutane oxidation in air, the production shifts from 33% selectivity to C_3H_6 with 80% isobutane conversion at a fuel/ O_2 ratio of 0.7 to 38% selectivity to $i-C_4H_8$ with only 25% isobutane conversion at a fuel/ O_2 ratio of 1.65. Throughout this composition region, the total olefin
20 selectivity remains high and fairly constant at about 60%.

EXAMPLE 12

i-Butane + O_2

Figure 10 shows the effect of a reduction in the amount of N_2 diluent present in the reactant stream. The
25 reactants, isobutane and O_2 (with 20% N_2 present for GC calibration) are preheated to 360°C prior to reaching the catalytic zone where they pass over a 5.1 wt. % Pt/ $\alpha-Al_2O_3$ ceramic foam catalyst. Figure 10 shows another substantial increase in the isobutane conversion while there is no
30 significant decrease in isobutylene selectivity. At a fuel/ O_2 ratio of 1.65, the isobutane conversion is now 75% with an isobutylene selectivity of 35%. the O_2 conversion has also increased to 95 to 98%. The selectivity to
35 isobutylene is nearly 45% at the stoichiometric ratio of oxidative dehydrogenation (fuel/ O_2 = 2.0) while the conversion is still greater than 50%.

The invention claimed is:

1. A process for the production of a mono-olefin from a gaseous paraffinic hydrocarbon having at least two carbon atoms or mixtures thereof comprising reacting said hydrocarbons and molecular oxygen in the presence of a platinum catalyst consisting essentially of platinum supported on a ceramic foam monolith consisting of the oxides of Al, Zr, Ca, Mg, Hf, Ti and mixtures thereof.
2. The process according to claim 1 wherein the platinum is supported on alumina monolith.
3. The process according to claim 1 wherein the platinum is supported on zirconia monolith.
4. The process according to claim 1 wherein the platinum is present in the substantial absence of palladium.
5. The process according to claim 1 wherein the platinum is present in the substantial absence of rhodium.
6. The process according to claim 1 wherein the platinum is present in the substantial absence of gold.
7. The process according to claim 1 wherein the platinum is present in the substantial absence of palladium, rhodium and gold.
8. The process according to claim 1 wherein less palladium, rhodium or gold is present than would causes a detectable decline in the effectiveness of the platinum in the dehydrogenation.
9. The process according to claim 1 wherein said gaseous paraffin and said oxygen have a flow rate in the range of 60,000 to 10,000,000 hr^{-1} GHSV.
10. The process according to claim 9 wherein said gaseous paraffin and said oxygen have a flow rate in the range of 300,000 to 3,000,000 hr^{-1} GHSV.
11. The process according to claim 1 wherein said gaseous paraffinic hydrocarbon comprises an alkane or mixture of alkanes having two to twenty carbon atoms.
12. The process according to claim 11 wherein said alkane or mixture of alkanes have two to eight carbon atoms.

13. The process according to claim 11 wherein said alkane or mixture of alkanes is ethane, propane, n-butane, isobutane, n-pentane, isoamylenes, n-hexane, isohexanes, n-heptane, isoheptane, octane, isooctanes or mixtures thereof.

14. The process according to claim 11 wherein said alkane or mixture of alkanes comprises ethane.

15. The process according to claim 11 wherein said alkane or mixture of alkanes comprises propane.

16. The process according to claim 11 wherein said alkane or mixture of alkanes comprises n-butane.

17. The process according to claim 11 wherein said alkane or mixture of alkanes comprises isobutane.

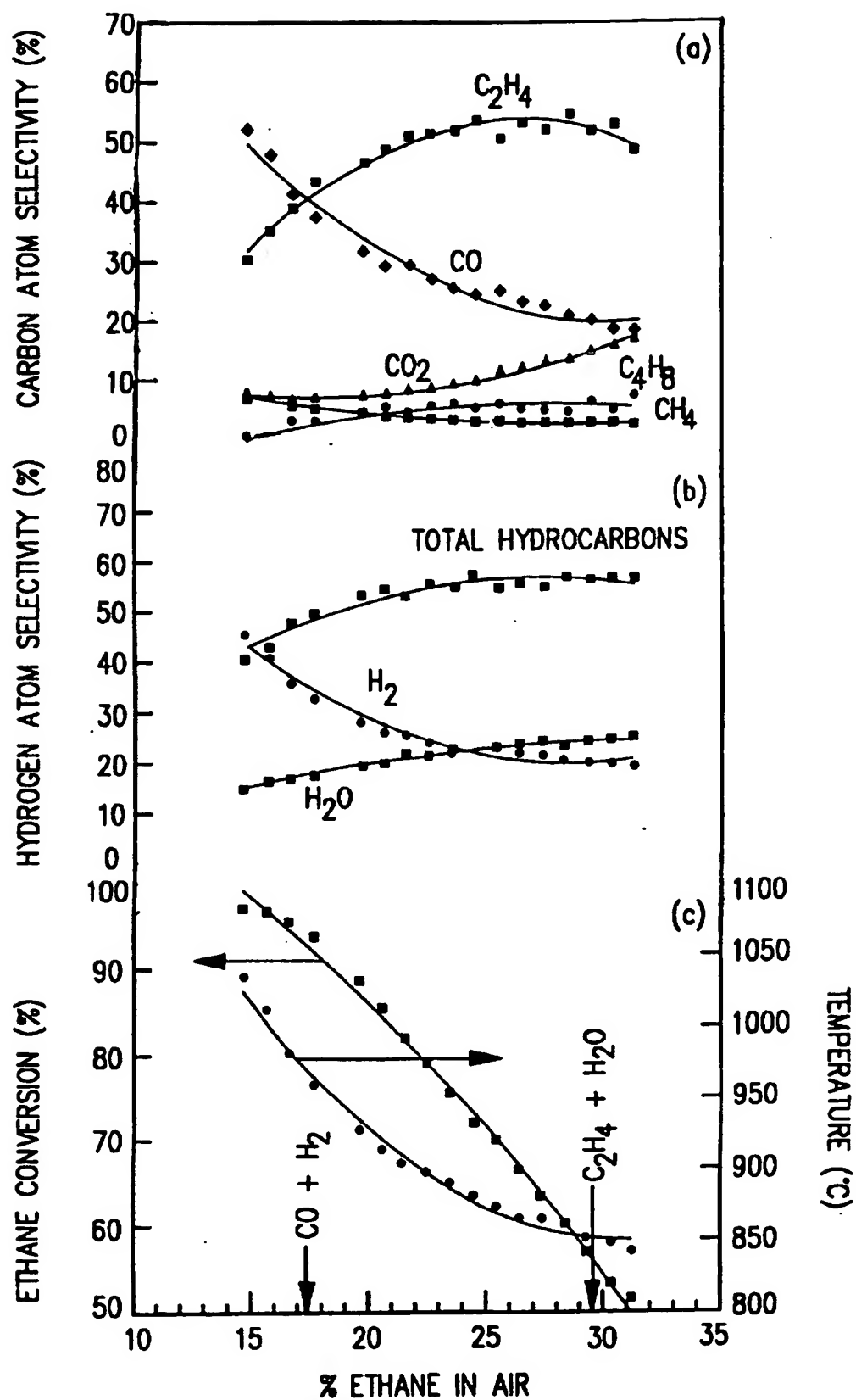
18. The process according to claim 1 wherein said paraffinic hydrocarbon and molecular oxygen is preheated prior to reacting.

19. The process according to claim 18 wherein said preheating is to a temperature in the range of 25 to 400°C.

20. A process for the production of corresponding olefins, comprising feeding a gaseous alkane or mixture of alkanes having two to twenty carbon atoms and molecular oxygen at a flow rate of 60,000 to 3,000,000 hr⁻¹ to a catalyst consisting essentially of platinum 0.2 to 20 wt% supported on a alumina monolith or zirconia monolith.

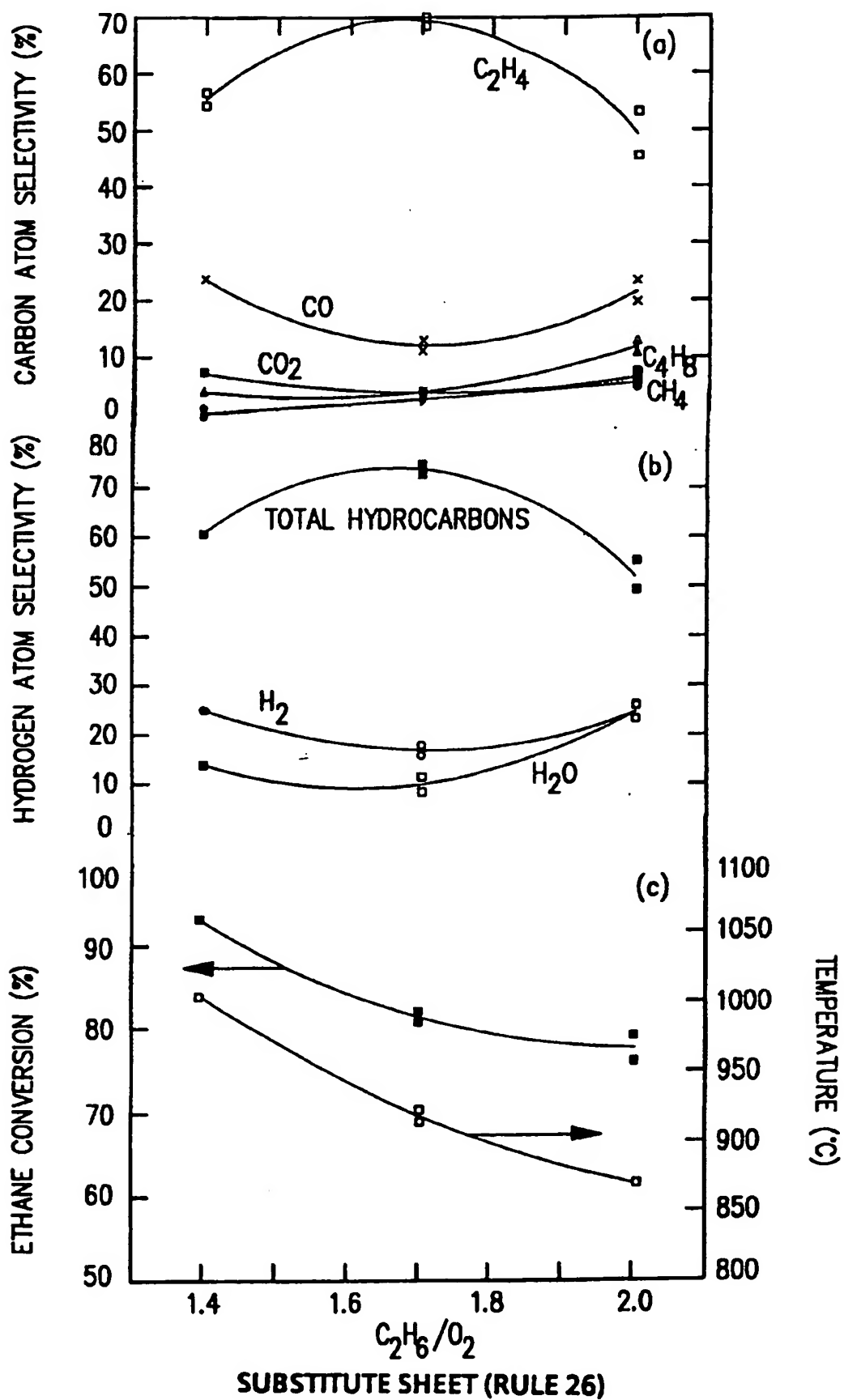
1/11

FIG. 1



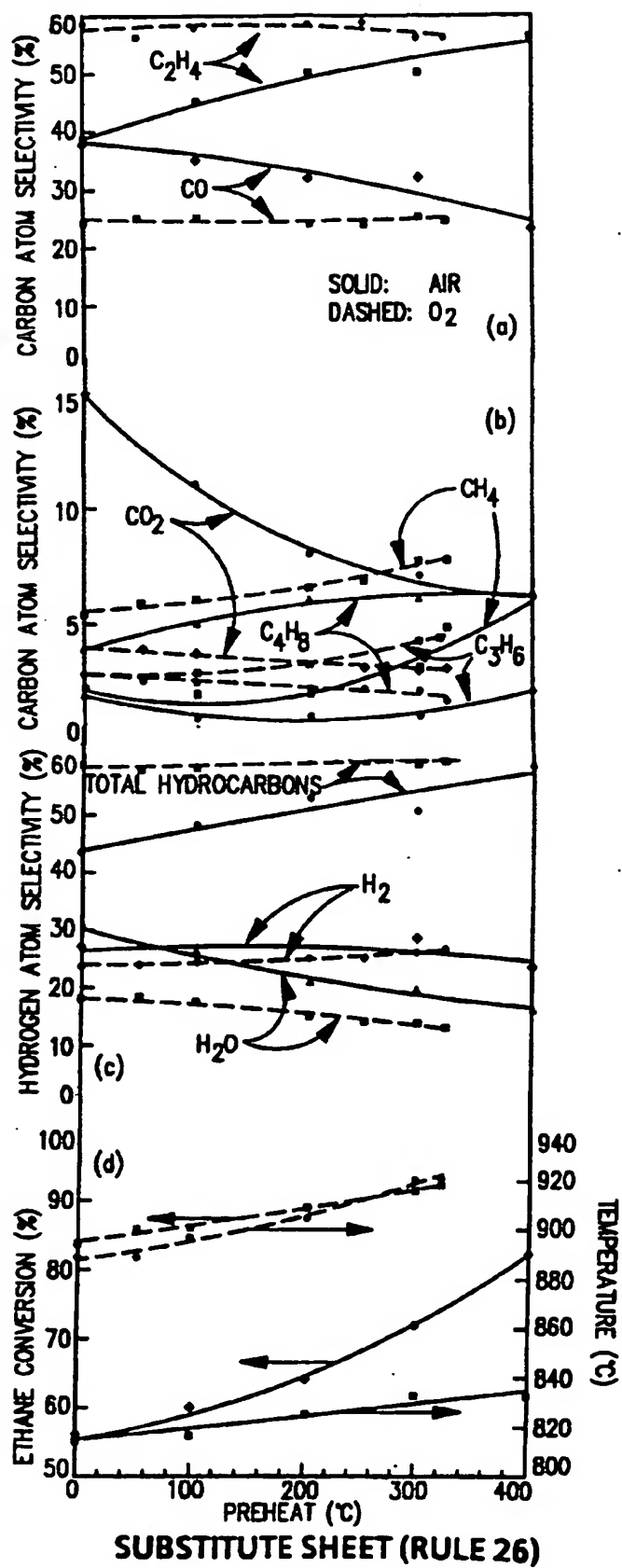
2/11

FIG. 2



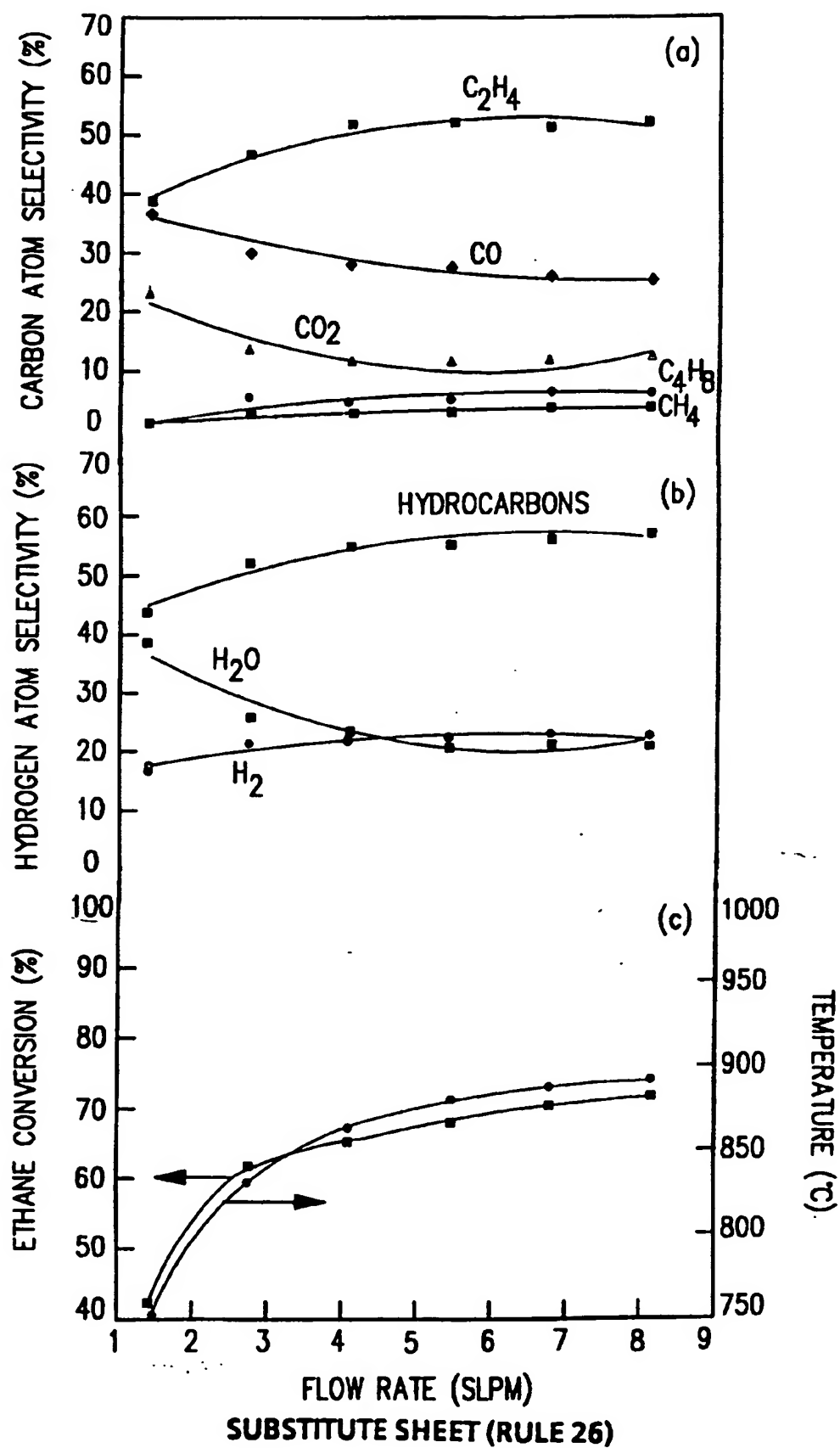
3/11

FIG. 3



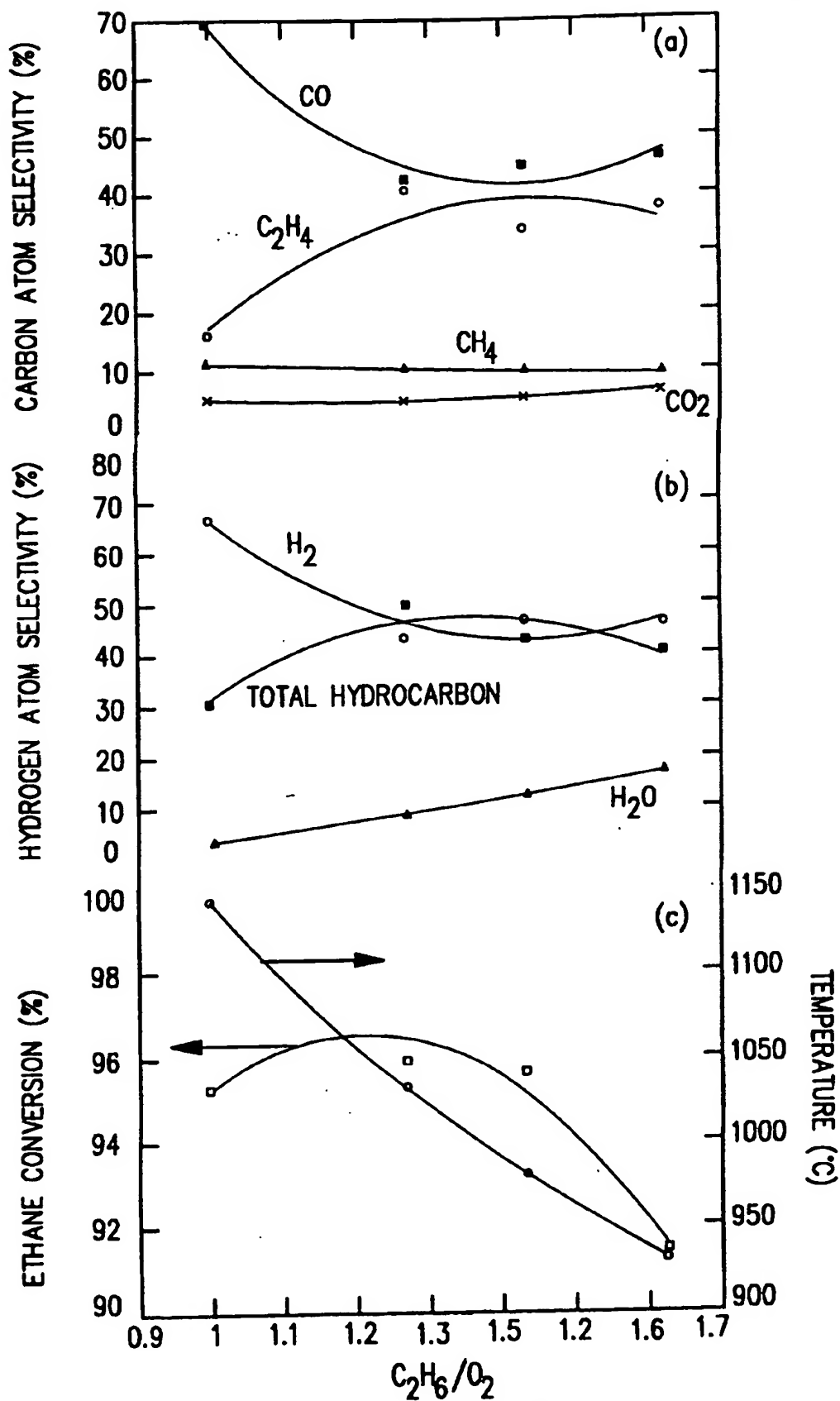
4/11

FIG. 4



5/11

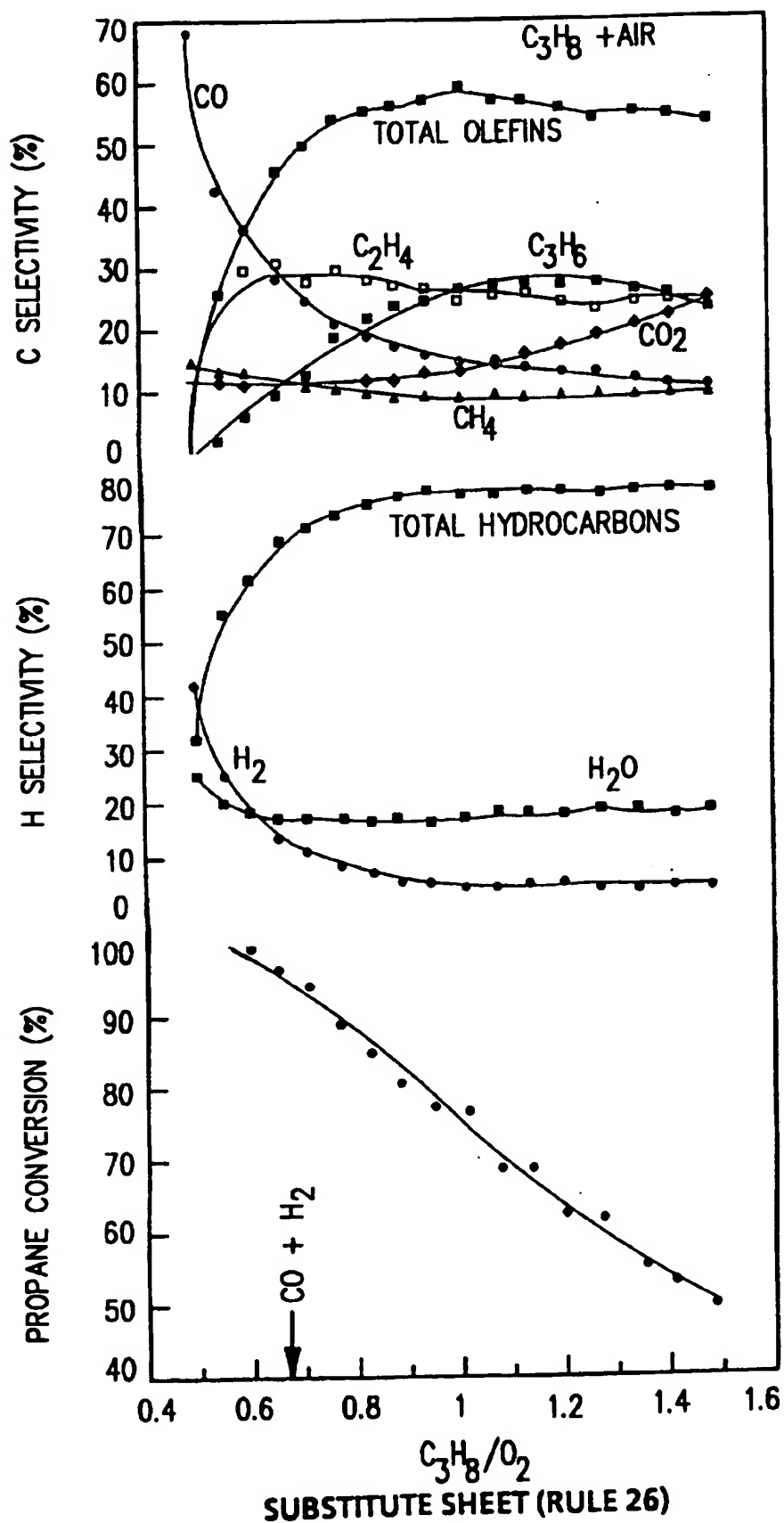
FIG. 5



SUBSTITUTE SHEET (RULE 26)

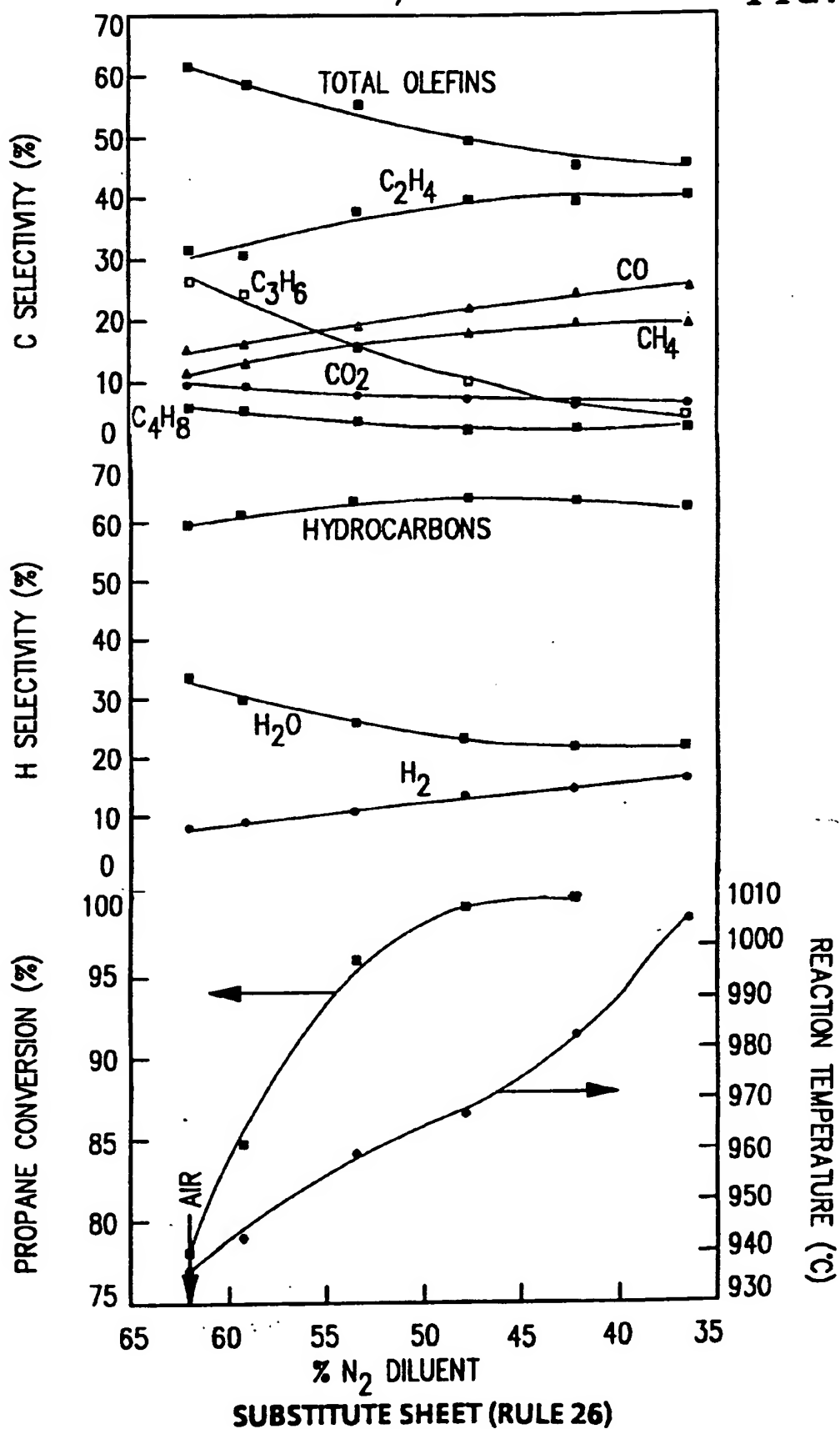
6/11

FIG. 6



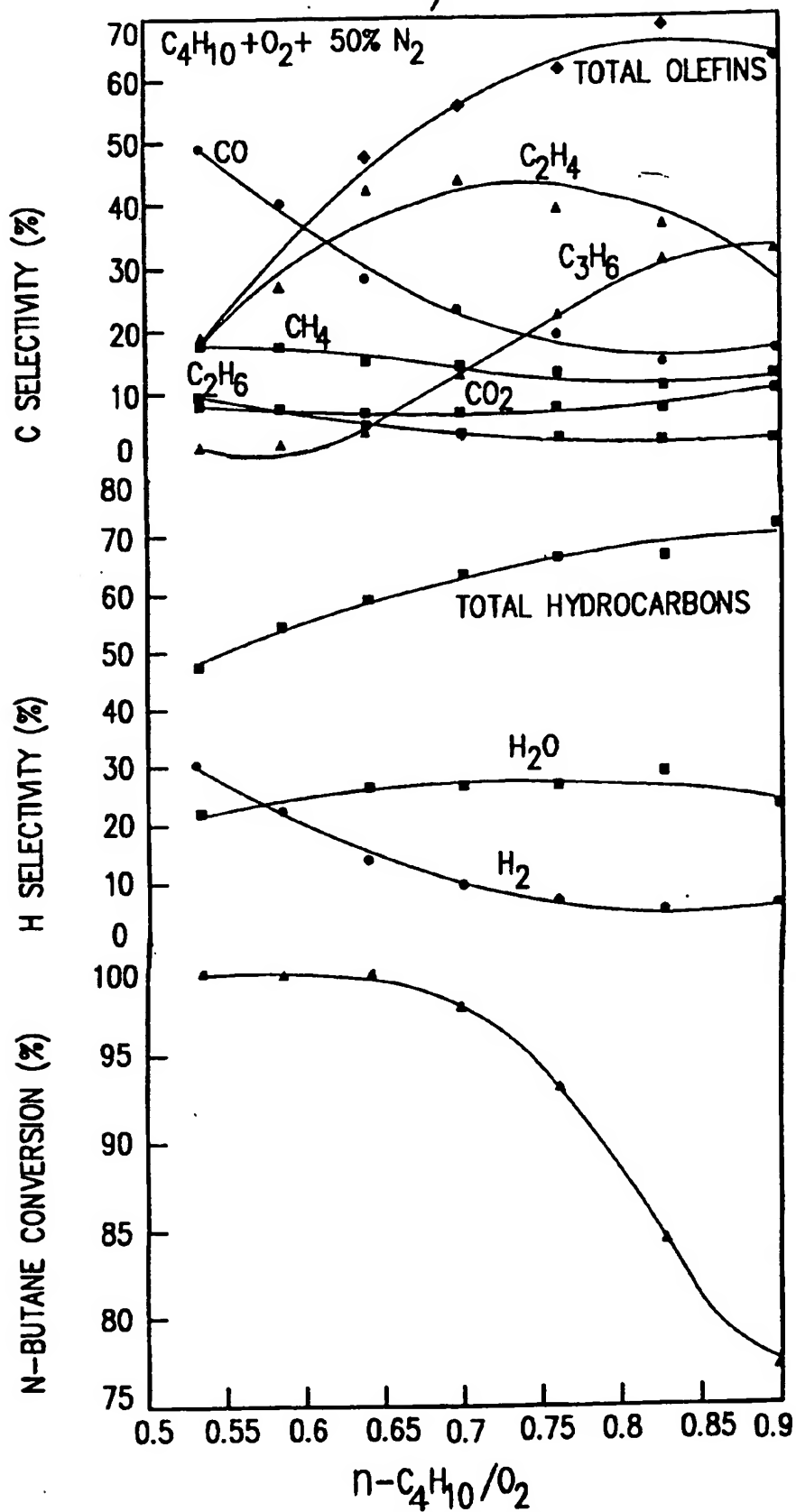
7/11

FIG. 7



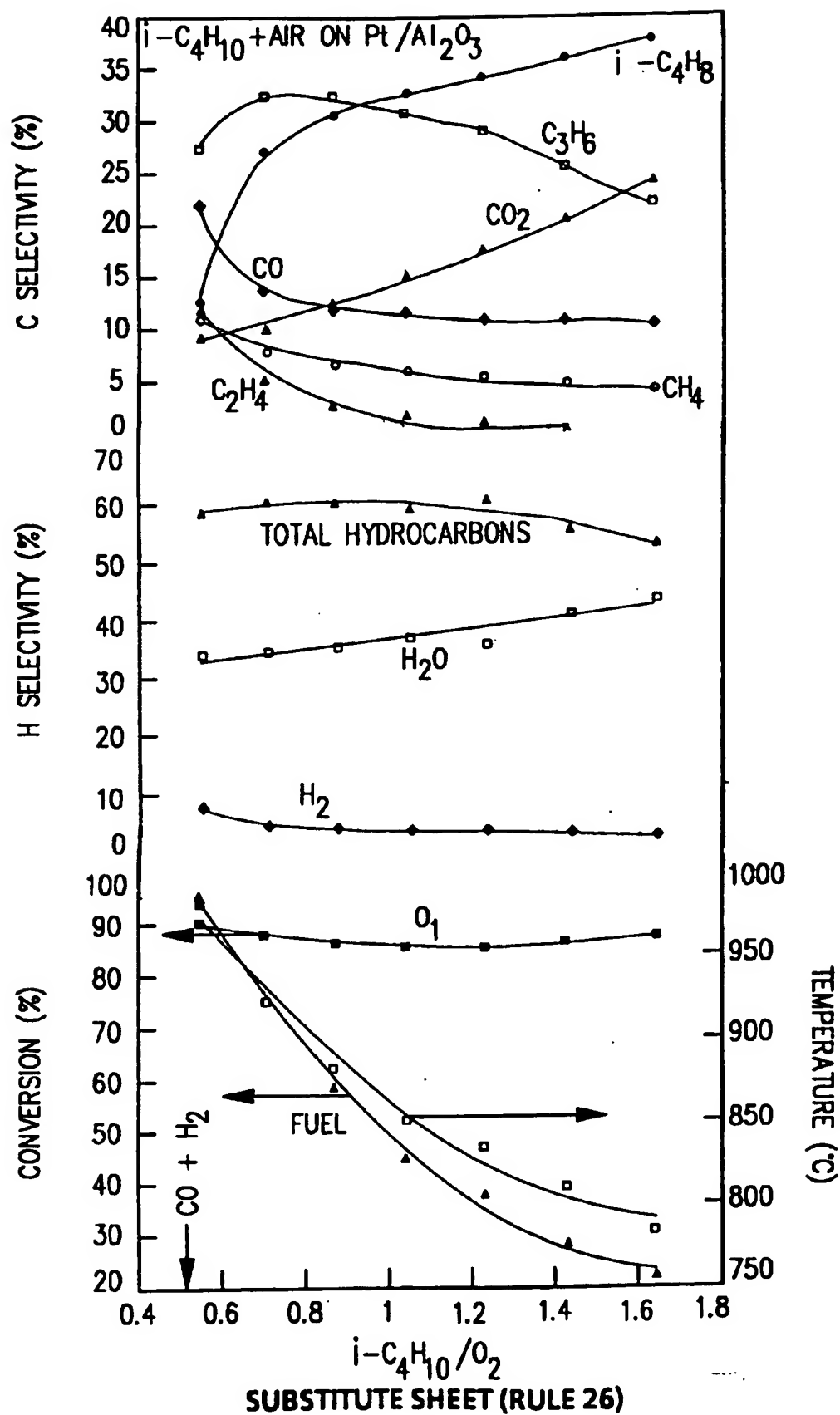
8/11

FIG. 8



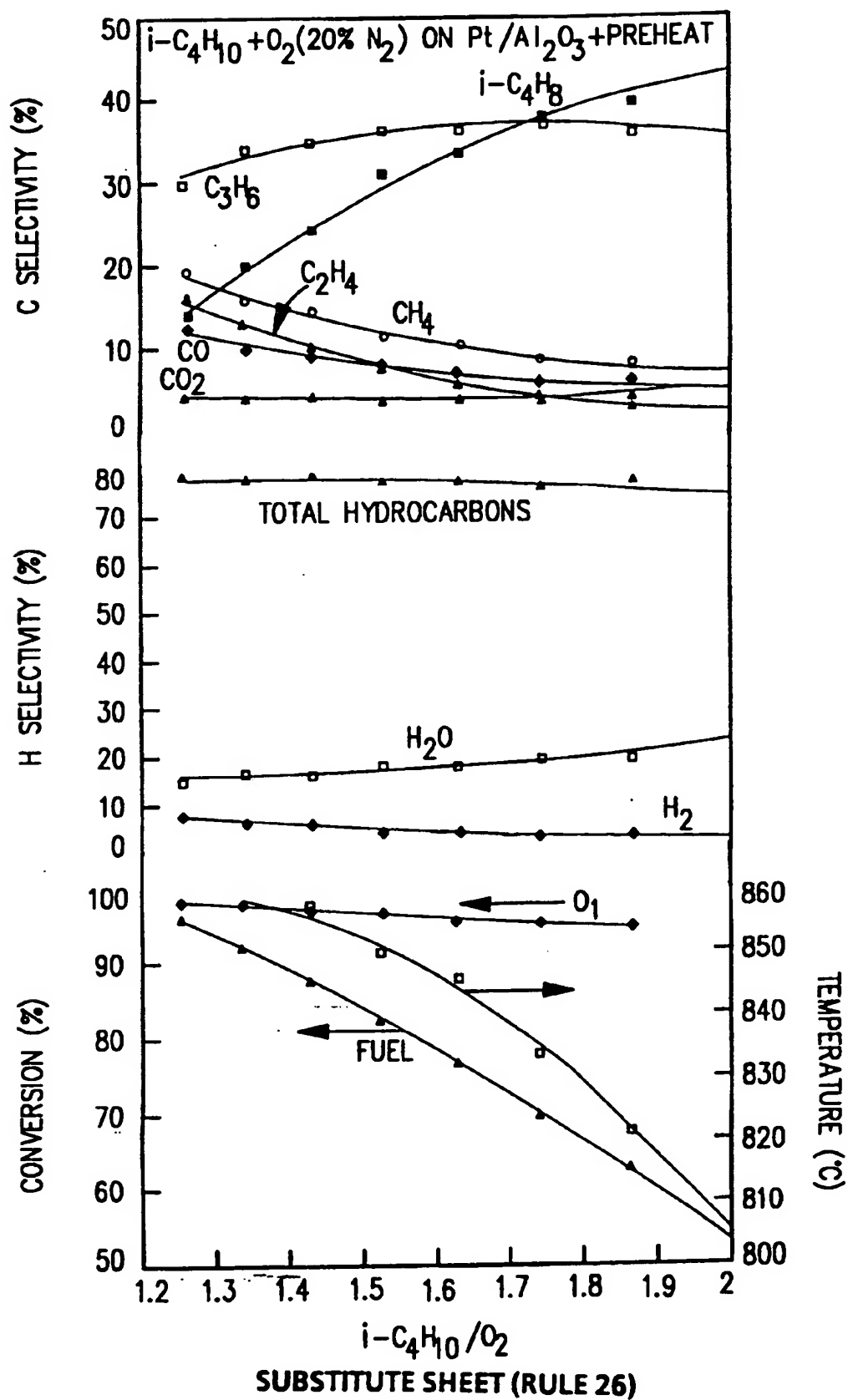
9/11

FIG. 9



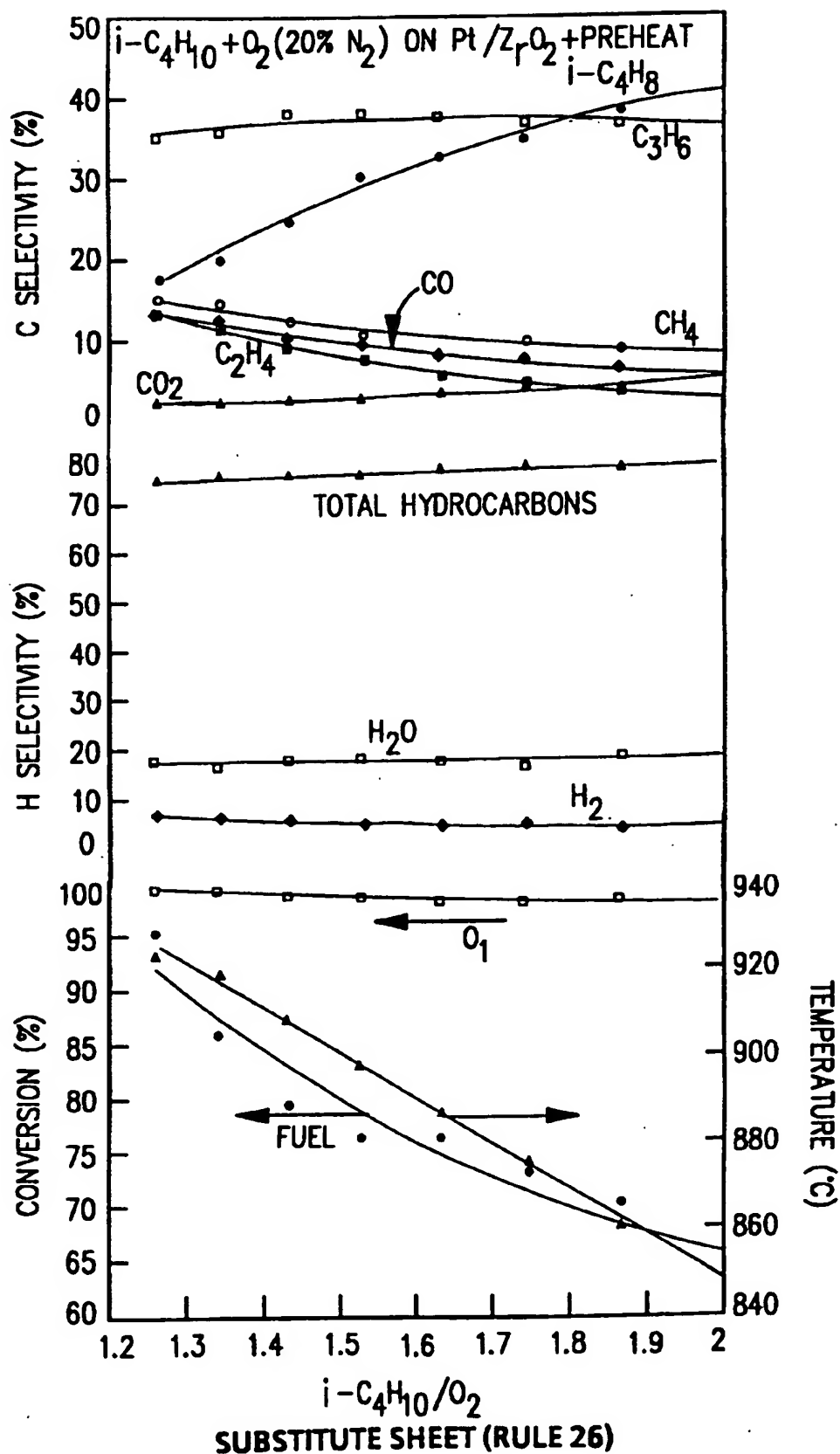
10/11

FIG. 10



11/11

FIG. 11



INTERNATIONAL SEARCH REPORT

International application No.
PCT/US95/12605

A. CLASSIFICATION OF SUBJECT MATTER

IPC(6) : C07C 5/333

US CL : 585/658, 660

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

U.S. : 585/658, 660

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	US, A, 4,940,826 (FONT FREDIE ET AL) 10 JULY 1990, abstract, claims, col. 2, lines 20-65.	ALL

☐ Further documents are listed in the continuation of Box C. ☐ See patent family annex.

* Special categories of cited documents:	"T" later documents published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention
"A" document defining the general state of the art which is not considered to be of particular relevance	"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone
"E" earlier document published on or after the international filing date	"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art
"L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)	"A" document member of the same patent family
"O" document referring to an oral disclosure, use, exhibition or other means	
"P" document published prior to the international filing date but later than the priority date claimed	

Date of the actual completion of the international search

30 NOVEMBER 1995

Date of mailing of the international search report

22 JAN 1996

Name and mailing address of the ISA/US
Commissioner of Patents and Trademarks
Box PCT
Washington, D.C. 20231

Facsimile No. (703) 305-3230

Authorized officer

BEKIR L. YILDIRIM

Telephone No. (703) 308-3586